ASAP

Work Order ID 79360

Wednesday, January 25, 2012 12:25:59 PM

79360

Item ID: D3290-041

Revision ID:

Item Name: Replacement Window Assembly

Start Date: 1/25/2012 **Start Qty:** 8.00 *8*

Required Date: 2/3/2012 **Req'd Qty:** 8.00 *8*

Reference:

Accept *N900040100*

Setup **Start** *NS1* **Stop** *NS2*

Cust Item ID:

Customer:

Run **Start** *NR1* **Stop** *NR2*

Approvals: **Process Plan:** M.C.J **Date:** 12/01/25 **Tooling:** ____ **Date:** ____

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Draw Nbr	Revision Nbr
D3290	~~DEO~~ Rev C

12/01/25

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100* Waterjet FLOW CNC Waterjet 6061 .063	FLOW WATER JET **Memo** 1-Cut as per Dwg D3290 (use prog. for D3290-1) Dwg Rev: C Prog Rev: C 2-Deburr if necessary	0.00 0.00				IB12-2-19 No F.A.I.			(8)
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00				IB12-2-19			
120 *120* QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00				M 12 02 '21 (8)			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ PAR #: _______ Fault Category: ________________ NCR: Yes No DQA: _____ Date: __________

Resolution: ________________ Disposition: ________________ QA: N/C Closed: __________ Date: __________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79360 *79360*

Wednesday, January 25, 2012 12:25:59 PM

Item ID: D3290-041 **Accept** *N900040100* **Setup Start** *NS1* **Stop** *NS2*

Revision ID:

Item Name: Replacement Window Assembly

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Required Date: 2/3/2012 **Req'd Qty:** 8.00 *8* **Customer:**

Reference:

Run Start *NR1* **Stop** *NR2*

Approvals: **Process Plan:** ____________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 **Memo**	0.00 0.00				8	(28) Bh Feb 21/2012.		
140 *140* Powdercoat Powder Coating W114480	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum **Memo** START TIME: 8:50 OVEN TEMPERATURE: 320°F FINISH TIME: 9:20	0.00 0.00				8 X ∅	M	12/02/22	
150 *150* QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00				8	BK	12-2-22	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79360 *79360*

Wednesday, January 25, 2012 12:25:59 PM

Item ID: D3290-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Replacement Window Assembly

Start Date: 1/25/2012 **Start Qty:** 8.00 *8* **Cust Item ID:**

Required Date: 2/3/2012 **Req'd Qty:** 8.00 *8* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

Stop *NR2*

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Small Fab Small Fab	Small Fab **Memo** Assemble as per Dwg D3290 Clean D3290-041 and place in plastic wrap	0.00 0.00				10	SAO		12-02-27 PTO⇒
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	S 12/02/27			(all)			
180 *180* Packaging Packaging	Identify as per dwg & Stock Location 219 **Memo**	0.00 0.00				12/2/27	SP		(10)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79360 *79360*

Wednesday, January 25, 2012 12:25:59 PM

Item ID: D3290-041 **Accept** *N900040100* **Setup Start** *NS1* **Stop** *NS2*

Revision ID:

Item Name: Replacement Window Assembly

Start Date: 1/25/2012 **Start Qty:** 8.00 *8* **Cust Item ID:**

Required Date: 2/3/2012 **Req'd Qty:** 8.00 *8* **Customer:**

Reference:

Run Start *NR1* **Stop** *NR2*

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release **Memo**	0.00 0.00				MLJ 12/02/20			

PTO ⇒

12-02-20 (10)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, January 25, 2012 12:26:03 PM

Work Order ID: 79360 *79360*

Parent Item: D3290-041 *D3290-041*

Parent Item Name: Replacement Window Assembly

Start Date: 1/25/2012 **Required Date:** 2/3/2012

Start Qty: 8.00 **Required Qty:** 8.00

Comments:
IPP B05.05.25Added Step 11KJ/JLM
IPP C06.05.09Ecn 798 EC
IPP Rev:D Now on Waterjet 06-06-16 JLM
IPP rev E rev C dwg 07.09.28 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 *M6061T6S.063* 6061-T6 .063 Sheet		Purchased	No			100	sf	352.5696	3.75 **	31.57895	B12-2-9		

Location	Loc Qty	Loc Code
MAT021	352.5695684	D3290-041
113608	0	B65144 — 3
116308	11.4555684	
117285	75.414	
119331	49.2	
119802	25.5	
120218	191	120218

8 PTO JJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2126 *D2126* Seal		Manufactured	No			160	f	575.7858	6.5 **	~~52~~ 65	SAD	12-02-27	

Location	Loc Qty	Loc Code
ST405	575.78579	
57106	4	
68336	71.78579	
76094	500	65

(D2126-0780) cut qty (1) at 78.00" as per dwg
per kit

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3290-3 *D3290-3* Window		Manufactured	No			160	Each	7.0000	1 **	8	SAD	12-02-27	

D3290-1 B65144 x3
~~D3290A1 x3 B62164~~

Location	Loc Qty	Loc Code
ST221	7	
75052	7	7

B79363

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W/O: 79360	WORK ORDER CHANGES					
DATE / **STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector
12-02-07	Used last 3 frames in stores D3290-1 B65144	SAD	12-02-27	(3)	12-02-27	12/02/07

Part No: D3290-041 **PAR #:** ______ **Fault Category:** ______ **NCR:** Yes No **DQA:** ______ **Date:** ______

Resolution: ______ **Disposition:** ______ **QA: N/C Closed:** ______ **Date:** ______

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B: **Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 79360
Description: REPLACEMENT	Part Number: D3290-041
Inspection Dwg: D3290-1 , Rev: C	Page 1 of 1

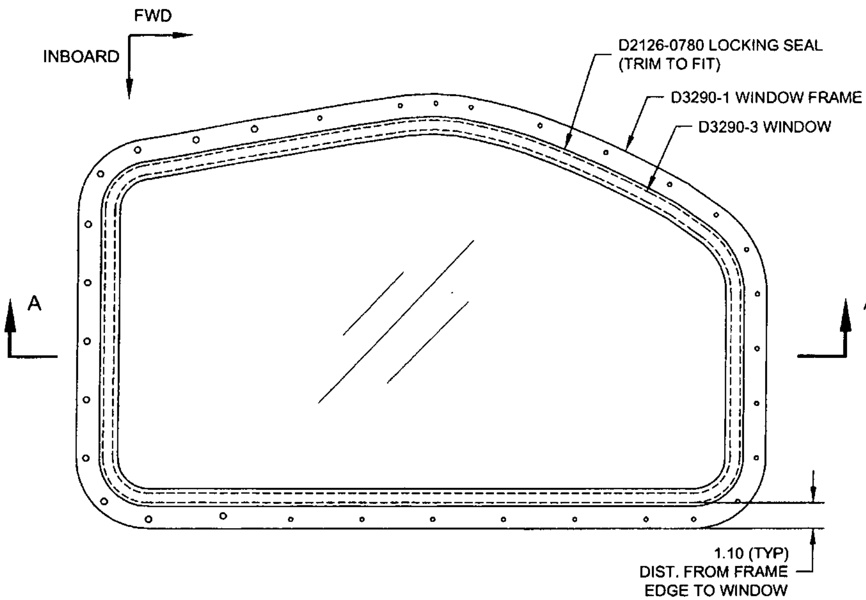
FIRST ARTICLE INSPECTION CHECKLIST

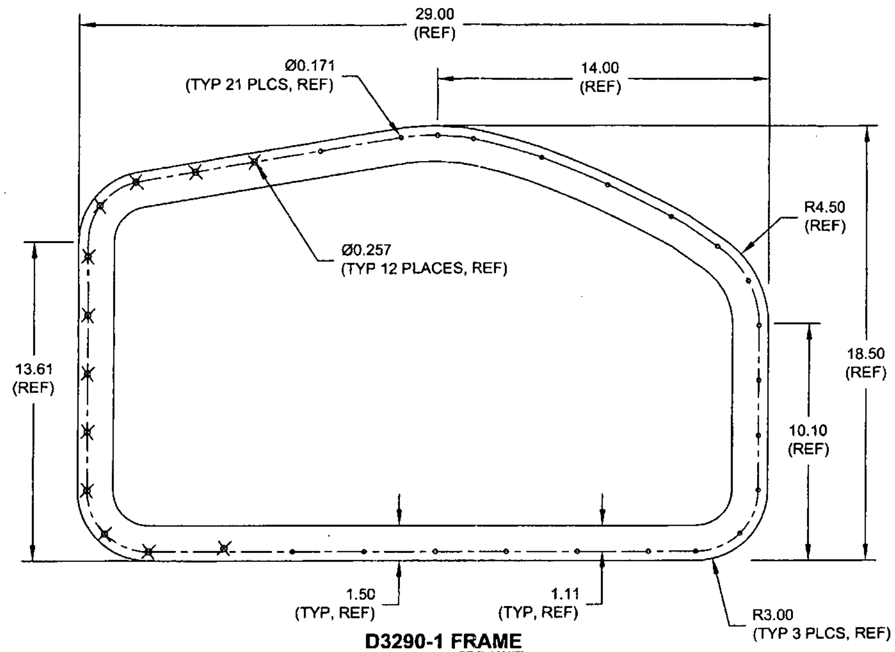
[X] First Article [X] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
∅ .171	+.005 - .001	.174	✓		V IB02	
∅ .257	+.006 - .001	.258	2		V	
24.00	+/- .030	24.00	2		T IB01	
18.50	+/- .030	18.50	2		T	
1.11	+/- .030	1.109	2		V	
1.50	+/- .030	1.509	2		V	
.063	+/- .010	.063	2		V	

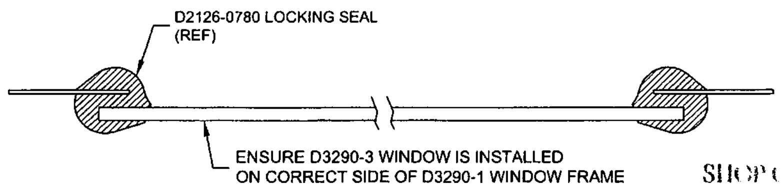
Measured by: IB	Audited by: [signature]	Prototype Approval:
Date: 12-2-19	Date: 12-02-21	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





D3290-1 FRAME



SECTION A-A
NTS

D3290-041 REPLACEMENT WINDOW ASSEMBLY

D3290-041 NOTES:
1) WEIGHT: 3.66 LBS

GENERAL NOTES:
1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
2) UNITS: INCHES UNLESS OTHERWISE NOTED

D3290-1 NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
OR
5052-H32 ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.040)
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
5) WEIGHT: 0.47 LBS

RELEASED 07.09.22
DEO ATTACHED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 79360 M.C.J.
12/01/25

UNDER REVIEW 09.07.19
PAIR 09-057
09/10/19

REV.	DESCRIPTION	BY	DATE
C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D3290 — REV. C — SHEET 1 OF 2
CHECKED		
MFG. APPR.		
APPROVED		TITLE: REPLACEMENT WINDOW ASSEMBLY — SCALE 1:5
DE APPR.		
DATE	07.07.24	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

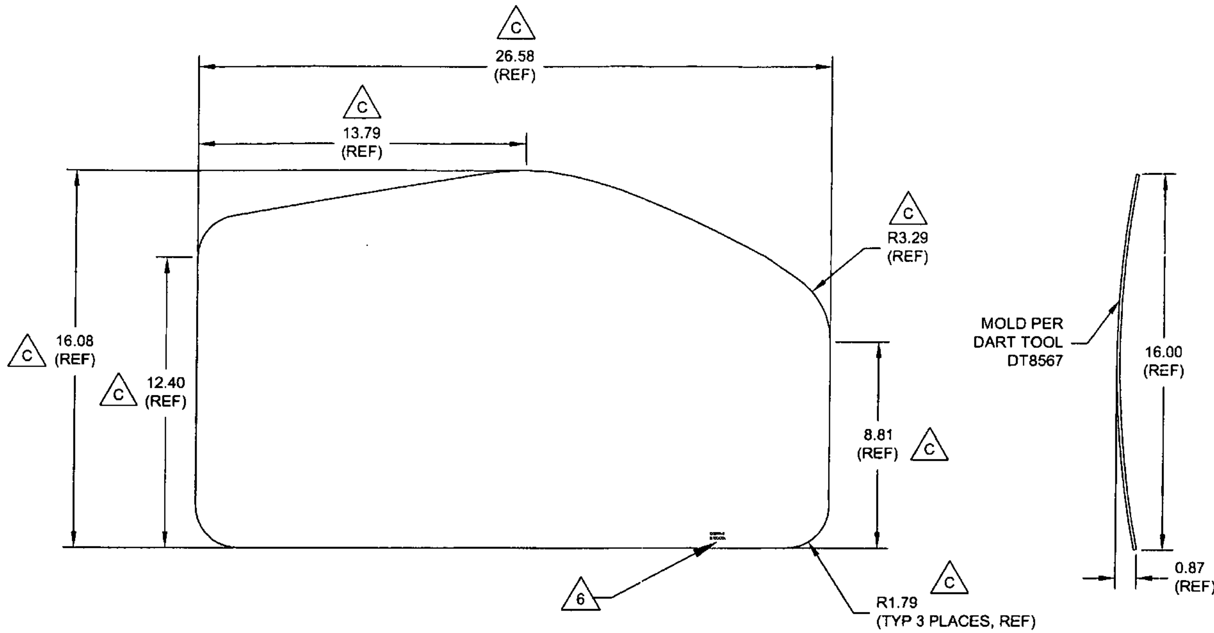
Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79360



D3290-3 WINDOW

B **D3290-3 NOTES:**

1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) REMOVE SHARP EDGES
6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
7) WEIGHT: 1.87 +/- 0.42 LBS
8) MOLD PER DART TOOL DT8567

UNDER REVIEW

DEO ATTACHED

RELEASED 07.09.22

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3290	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY	1:5
DATE	07.07.24		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79360

DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.	
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21	DATE 09/09/21	

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
OR
5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED 2009-10-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries